



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/03
Rev. No. 01
Rev. Date 31-07-2013

6857

Final Inspection (Pellet Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.		9999	45150
2.	Visual Inspection	ok - 3.2 mm	(SSCW)	Run 0 Dongle - 406A/B
3.	Pellet Die No.		10564	607-OK
4.	Hardened by		work for new	Relief - OK
5.	Received by after hardening (Name)		Janjan	(3-3) > 12 mm
6.	Hardness achieved on 1 st side		51.0 - 50.6 HRC	Relief ϕ 3.8 > 5 mm
7.	Hardness achieved on 2 nd side		50.5 - 49.4 HRC	Counts - OK
8.	Ovality after hardening 1 st side		(0.5) mm	PCD - 565 mm
9.	Ovality after hardening 2 nd side		(0.3) mm	Tapping M20
10.	Outside Diameter		620 mm	Deep - 18.8 mm
11.	Inside Diameter		520 mm	Tapping M16
12.	Width of die		222 mm	Key - 12
Inspected By (Sign) & Date		Janjan 8/8/23		
1.	Finish Fitting size 1 st side	621 ϕ .10 ϕ .10 mm Tapper 12°		Undercut = .52.3 mm
2.	Finish Fitting size 2 nd side	621 ϕ .11 ϕ .11 mm Tapper 12°		
3.	Finish size made by			
Inspected By (Sign) & Date		Janjan 8/8/23		
1.	Supplied to (Customer Name)	Hyam Tech alliance, Tamil Nadu		
2.	Dispatch Date			
Reported By (Sign) & Date		Janjan 8/8/23		

Reviewed by (Engineer-CNC)

Manager-CNC